

Work Order ID 73773

Thursday, September 15, 2011 9:58:24 AM



Page 1

Item ID: D3808-041

Accept



Setup Start



Revision ID:

Item Name: Seat Rail Assembly

Stop



Start Date: 9/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

mf

Date: 11-09-15 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3808

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Install Plunger as per Dwg D3808. 2-Install helicoils x5 as per Dwg D3808.

G. Sullivan 9/25/11 (2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sullivan 9/25

(x2)

120

Identify as per dwg & Stock Location: 262

0.00



Packaging

Memo

0.00

Packaging

Pull 9/26/11 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/27

ME 11-10-26

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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, September 15, 2011 9:58:19 AM

Page 1

Work Order ID: 73773

Parent Item: D3808-041

Parent Item Name: Seat Rail Assembly





Start Date: 9/15/2011

Required Date: 9/16/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3808-1  Seat Rail		Manufactured	No			100	Each	3.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST262				3					
					71150			3					
D3810-1  Hand Retractable Spring Plunger		Manufactured	No			100	Each	10.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST084				10					
					57319			10					
MS21209C0815  Heli Coil, screw locking, red		Purchased	No			100	Each	4.0000	4	8			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST304				4					
					118159			4					
MS21209C6-10  Heli Coil, screw locking, red		Purchased	No			100	Each	20.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST304				20					
					108847			20					

Handwritten notes and signatures:

- Next to D3808-1: *EP 11/10/25*
- Next to D3810-1: *2*
- Next to MS21209C0815: *2*
- Next to MS21209C6-10: *3*
- Bottom right: *1119316 (ST)*

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

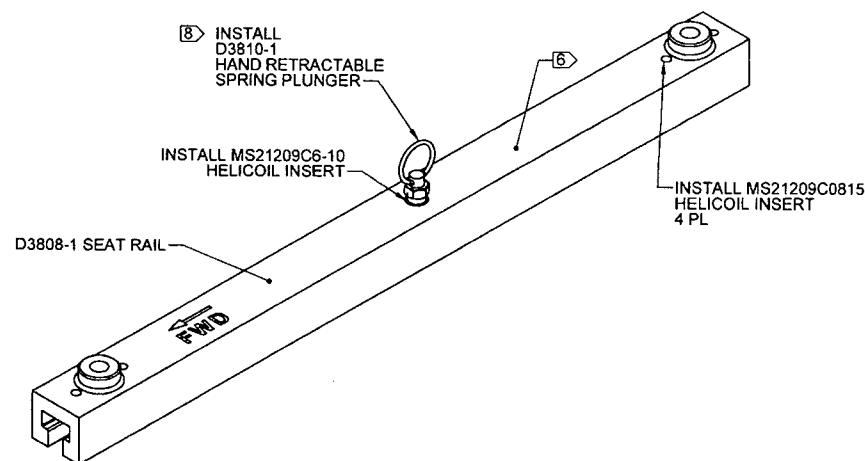
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QTY -041	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)



D3808-041 SEAT RAIL ASSEMBLY

D3808-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

A		NEW ISSUE		RF	08.08.08
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWN	RF			SHEET 1 OF 2	
CHECKED		DRAWING NO. D3808		SCALE	
MFG. APPR.		TITLE		NTS	
APPROVED		SEAT RAIL ASSEMBLY			
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DATE	08.08.08				

#73773

RELEASED

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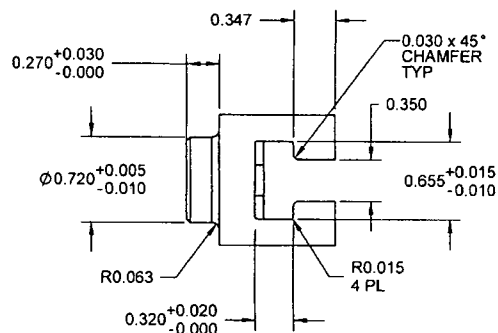
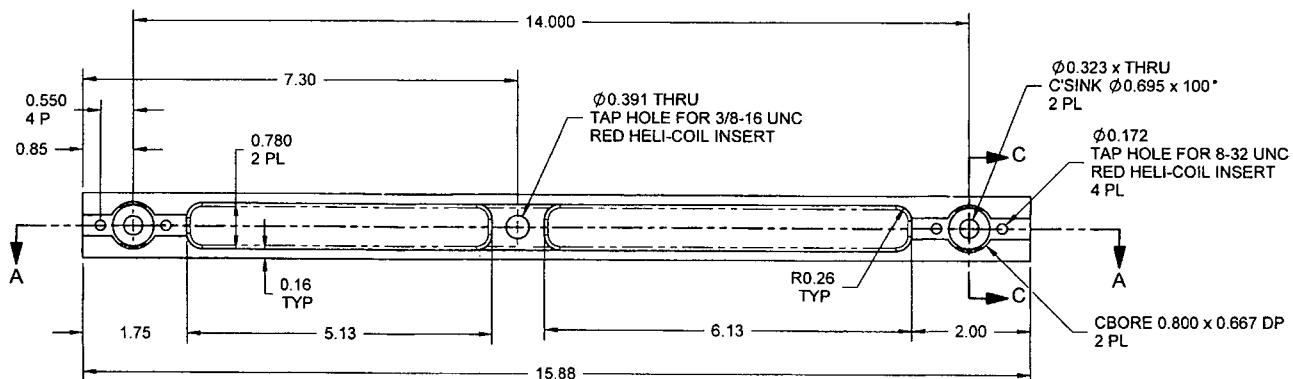
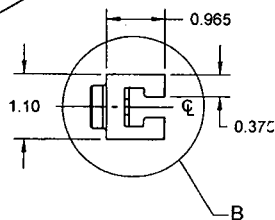
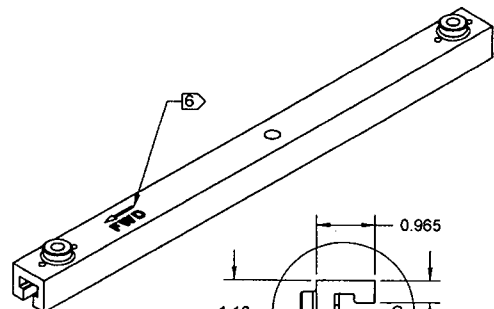
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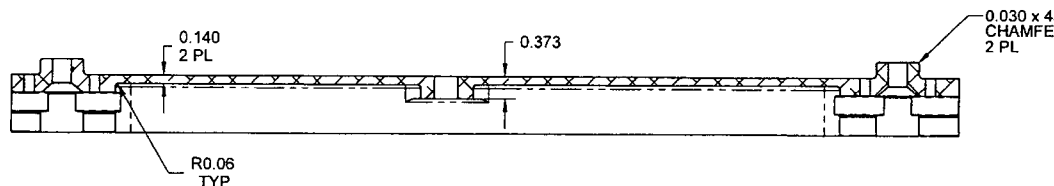
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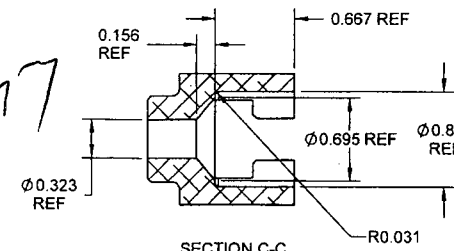
NOTE: Date & initial all entries



DETAIL VIEW B



SECTION A-A



SECTION C-C

D3808-1 SEAT RAIL

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO. D3808	REV. A
MFG. APPR.		TITLE SEAT RAIL ASSEMBLY	SCALE N/A
APPROVED		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
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DATE	08.08.08		

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128-2-30-112

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